

Work Order ID 105757

\*105757\*

Page 1

August-16-13 11:42:34 AM

Item ID: D3188-2M Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: SPACEPOD BODY RH  
 Start Date: 8/16/13 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 9/13/13 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 13-08-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start \*NR1\*  
 Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3188	Rev F								
100	PURCHASING	0.00							
*100*									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>20980</u>								
	Description: D3188-2MBODY								
	SHIP: QTY (8) D2213 Spacers								
	Supplier: Delastek								
	Conformity Certificate and Process sheet required								
	Ship 2 Items from Previous steps								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
*110*									
Packaging	Memo	0.00							
Packaging	Ensure a copy of certification of conformity and process sheet from Delastek is attached.								

C213081190

13/12/30

1X SP14-10-23

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other

# Work Order ID 105757

August-16-13 11:42:34 AM

**\*105757\***

Page 2

Item ID: D3188-2M Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: SPACEPOD BODY RH  
Start Date: 8/16/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 9/13/13 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: <u>comp 107.127</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

14-05-13  
14-10-28  
14-05-13

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions  <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

August-16-13 11:42:38 AM

Page 1

Work Order ID: 105757

**\*105757\***

Parent Item: D3188-2M

**\*D3188-2M\***

Parent Item Name: SPACEPOD BODY RH

Start Date: 8/16/13

Required Date: 9/13/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC  
IPP rev B rev D dwg 07.03.07 ec  
IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2213		Manufactured	No			100	Each	106.0000	8	8			
-------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

**\*D2213\***

Insert

\*\*

CL 13/08/19

Location

Loc Qty

Loc Code

ST006

106

30809

106

D3188-2P

Purchased

No

110

Each

1.0000

1

1

**\*D3188-2P\***

Spacepod Body

105 757

\*\*

ET 14-05-13

Location

Loc Qty

Loc Code

CA

1

95145

1

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

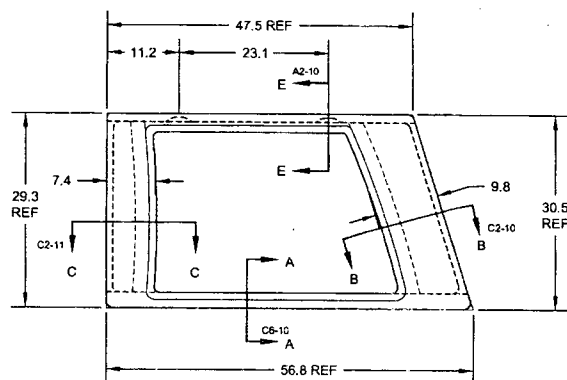
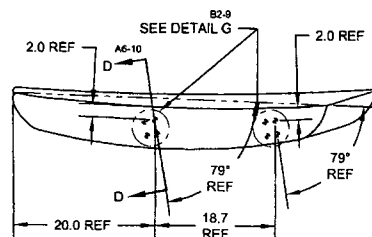
QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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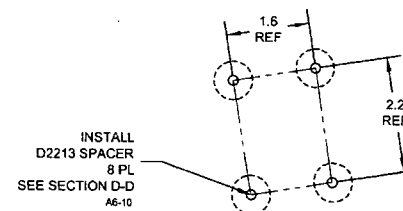
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

**FAULT CATEGORY**

Landing Gear	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
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		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



**D3188-2M SPACEPOD BODY**



**DETAIL G** D6-8

105757 ML3  
13-08-16

**RELEASED**  
2009-10-20

**D3186-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	RE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 9 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



DELASTEK Inc.  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice No.	49996
Customer No.	DART US

## Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

## Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
29-11-2013	11-09-2013	23834	Chantal Lavoie	20980	Net 30 days USA
Ship Via	F.O.B.	Salesperson	GST/PST		
FEDEX P1 Collect	Point de départ	Mathieu Doucet, ext.690			
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0071	Line 5 N° D3188-2M, Spacepod Body RH U of M: Chaque Dwg. D3188 Rév.: F B105757 Serial # 55563 Lot # 55563	
1	0	1	DKC134-0060	Line 6 N° D3186-2M Spacepod Door RH U of M: Chaque Dwg. D3186 Rév.: E Serial # 55559 Lot # 55559	

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

*Mathieu Doucet*

Quality department

AQ-357

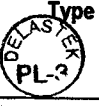
☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.



Date: Lundi, 2013-09-16 13:45:18  
 Utilisateur: Mario Chantal

## Feuille de Procédé

4/ ASAP

<b>Client</b>	: DART US DART AEROSPACE	<b>Nom Dessin</b>	: SPACEPOD BODY RH
<b>Numéro Job</b>	: 55563	<b>Numéro Article</b>	: DKC134-0071
<b>Numéro</b>	: 3763	<b>Numéro Dessin</b>	: -
<b>Numéro B.A.</b>	:	<b>Projet Numéro</b>	: DK-362
<b>Cette fois</b>	: 2013-09-16 No. :	<b>Révision dessin</b>	:
<b>Prsht Rev.</b>	: NC	<b>Matériel</b>	: Fibre 7781 et résine 411-350
<b>Prem. fois</b>	: -	<b>Date Dûe</b>	: 2013-09-16 Qté: 1 Ud UNITE
<b>Job précédente</b>	: 55562		
<b>Écrit par</b>	: 		
<b>Vérifié &amp; Approuvé par</b>	:		
<b>Commentaires</b>	: N° de dessin: D3188-2M rev. F		

E.O.: N/A

 Feuille de Procédé Rév.: 06 AMB0349 remplacé par  
 AMB0511 (réf. RFC #226)

Formulaire d'inspection: N/A

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou	Description :
---------	------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

<b>Comment</b>	Qty.: 0.050 UNITE(s)/Unit	Total : 0.050 UNITE(s)
	N° 83634, Frekote Loctite Wolo	N° de Lot: 1-42289-1

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



<b>Comment</b>	Setup: 0.00Hrs/ Run: 5.0000Min	Total Run : 0.0833Hrs
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Faire la préparation du moule selon IF134-0020.

 Date: 25/10/13 Sceau: 

3.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

<b>Comment</b>	Qty.: 9.84 VERGE(s)/Unit	Total : 9.84 VERGE(s)
	Tissu à délaminer Release ply B	# de Lot: N/A

4.0	AAC1887	Wrighton 5200 Bleu P3
-----	---------	-----------------------

<b>Comment</b>	Qty.: 9.27 VERGE(s)/Unit	Total : 9.27 VERGE(s)
	Wrighton 5200 Bleu P3	# de Lot: N/A

5.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

<b>Comment</b>	Qty.: 6.00 VERGE(s)/Unit	Total : 6.00 VERGE(s)
----------------	--------------------------	-----------------------

Date: Lundi, 2013-09-16 13:45:18

Utilisateur: Mario Chantal

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 55563

Nom Dessin: SPACEPOD BODY RH  
Numéro: DKC134-0071

Numéro Job:



# Séq.: Machine ou Opération: Description :

6.0 AC0943 Stretchlon 200 poche à vide Vert

Comment Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 11.40 VERGE(s)/Unit Total : 11.40 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-41291-1

8.0 AMB0511 N° TG-13-U, Fiberglass 13 oz

Comment Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

9.0 AMB0213 WR1850 Roving 18oz. x 50"

Comment Qty.: 0.350 KILOGRAMME(s)/Unit Total : 0.350 KILOGRAMME(s)

WR1850 Roving 18oz. x 50"

N° de Lot: 1-35539-1

10.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 4.0000 ROULEAU(s)/Unit Total : 4.0000 ROULEAU(s)

11.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Tailler les tissus selon IF134-0020.

Date: 24/10/13

Sceau: 4460 R.L.



12.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0640 GALLON(s)/Unit Total : 0.0640 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829

13.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 2.000 LITRE(s)/Unit Total : 2.000 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-42702-1 et 1-43187-1

14.0 AAC1540 Fibre de verre Miapoxy 66

Comment Qty.: 0.0040 GALLON(s)/Unit Total : 0.0040 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-40769-1

15.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Laminer la 1ère coquille selon IF134-0020.

Date: 25/10/13










Sceau: 4460 R.L.



Date: Lundi, 2013-09-16 13:45:18

Utilisateur: Mario Chantal












**Feuille de Procédé**

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> SPACEPOD BODY RH	
<b>Numéro Job:</b> 55563	<b>Numéro:</b> DKC134-0071	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
16.0	AMB0355	ATC core-cell A500 plain 4'x8' 1" thick
<b>Comment</b>	Qty.: 0.750 FEUILLE(s)/Unit Total : 0.750 FEUILLE(s) ATC core-cell A500 plain 4'x8' 1" thick N° de Lot: <u>1-38256-1</u>	
17.0	TAILLAGE	Faire le taillage du matériel
		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs  Tailler et ajuster les Foam Core selon IF134-0020.  Date: <u>1-11-13</u> Sceau: <u>4460RL</u>	
18.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b>	Qty.: 0.136 KILOGRAMME(s)/Unit Total : 0.136 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-43187-1</u>	
19.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b>	Qty.: 0.0096 GALLON(s)/Unit Total : 0.0096 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-29829-1</u>	
20.0	FINITION	Finition Générale
		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs  Sceller les foam core selon IF134-0020.  Date: <u>1-11-13</u> Sceau: <u>4460RL</u>	
21.0	PERCAGE	Perçage de trous
		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Perçer les foam core selon IF134-0020.  Date: <u>1-11-13</u> Sceau: <u>4460RL</u>	
22.0	AAC1611	Polybond B46F
<b>Comment</b>	Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s) Polybond B46F N° de Lot: <u>1-40597-1</u>	
23.0	ASSEMBLAGE	Assemblage mécanique
		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  Installer les foam core selon IF134-0020.	

Date: Lundi, 2013-09-16 13:45:18

Utilisateur: Mario Chantal

## Feuille de Procédé

<b>Client:</b> DART US DART AEROSPACE	<b>Nom Dessin:</b> SPACEPOD BODY RH	
<b>Numéro Job:</b> 55563	<b>Numéro</b> DKC134-0071	
Numéro Job: 		
<b># Séq.:</b>	<b>Machine ou Opération:</b>	<b>Description :</b>
Date: <u>6/11/13</u> Sceau: <u>4460 R.L.</u> 		
24.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler
<b>Comment</b>	Qty.: 0.050 GALLON(s)/Unit Total : 0.050 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: <u>1-43091-1</u>	
25.0	FINITION	Finition Générale
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs  Usiner les foam core selon IF134-0020. Date: <u>13/11/13</u> Sceau: 	
26.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
<b>Comment</b>	Qty.: 1.600 KILOGRAMME(s)/Unit Total : 1.600 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-43187-1</u>	
27.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b>	Qty.: 0.0536 GALLON(s)/Unit Total : 0.0536 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
28.0	LAMINAGE	Faire le laminage
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  Laminer les plis de 9oz selon IF134-0020. Date: <u>14/11/13</u> Sceau:  <u>4460 R.L. 4499 D.B.</u>	
29.0	TRIMAGE	Trimage
 		
<b>Comment</b>	Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs  Faire le taillage selon IF134-0022. Date: <u>15/11/13</u> Sceau: 	
30.0	AMB0286	Catalyst N° DDM-9
<b>Comment</b>	Qty.: 0.0144 GALLON(s)/Unit Total : 0.0144 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
31.0	AAC1540	Fibre de verre Miapoxy 66
<b>Comment</b>	Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s) Fibre de verre Miapoxy 66 N° de Lot: <u>1-40769-1</u>	

Date: Lundi, 2013-09-16 13:45:18

Utilisateur: Mario Chantal

**Feuille de Procédé**Client: DART US DART AEROSPACE  
Numéro Job: 55563Nom Dessin: SPACEPOD BODY RH  
Numéro DKC134-0071

Numéro Job:



# Séq.: Machine ou Opération: Description :

32.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.450 KILOGRAMME(s)/Unit Total : 0.450 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-43187-1

33.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs

Faire le laminage des derniers plis 9oz selon IF134-0020.

Date: 19/11/13 Sceau: 4460 R.L.

34.0 AAC1610 Spacer N° D2213

Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)  
Spacer N° D2213 N° de Lot: 1-42317-1

35.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs

Faire l'assemblage des inserts selon IG 0097.

Date: 20/11/13 Sceau: 4460 R.L.

36.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-43178-2

37.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-40909-1

38.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer la pièce selon IG 0008.

Date: 22-11-13 Sceau: 4460 RL - 4499 DB-

39.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs













Préparer et appliquer le primer selon IG 0008.

Date: 22/11/13 Sceau: 20 # de fiche de mélange: 6510

Date: Lundi, 2013-09-16 13:45:18

Utilisateur: Mario Chantal

## Feuille de Procédé

Client:	DART US DART AEROSPACE	Nom Dessin:	SPACEPOD BODY RH
Numéro Job:	55563	Numéro	DKC134-0071
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
40.0	AAC1492	N° P-15-3, Adtech Micro Ultra Filler	
Comment	Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s) N° P-15-3, Adtech Micro Ultra Filler # de Lot: _____		
41.0	FINITION	Finition Générale	
 			
Comment	Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs  Faire les réparations de finition s'il y a lieu selon IG 0008.  Date: <u>26/11/13</u> Sceau: <u>4499</u> <u>DB</u>		
42.0	AAC1021	Dupont Primer N° 7704S	
Comment	Qty.: 0.5000 UNITE(s)/Unit Total : 0.5000 UNITE(s) Dupont Primer N° 7704S N° de Lot: <u>1-43178-2</u>		
43.0	AAC1101	N° 7775S, Dupont Activator - Reducer Chromabase	
Comment	Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s) N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: <u>140909-1</u>		
44.0	PRIMER	Application primer	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Préparer et appliquer le primer selon IG 0008.  Date: <u>28/11/13</u> Sceau:  # de fiche de mélange: <u>6515</u>		
45.0	INSPEC FINAL	Inspection finale	
 			
Comment	Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs  Faire l'inspection générale de la pièce selon le dessin par le département de la qualité.  Date: <u>29/11/13</u> Sceau:  Initiales: <u>MA</u>		
46.0	EMBAL / ENTREPO	Emballage & Entreposage	
 			
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs  Faire l'emballage selon IG 0057.  <u>NOV</u> Date: <u>JUN 29 2013</u> Sceau: _____		



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*OUTSTANDING PO REPRINT\*\*\*

Purchase Order ID PO20980

Purchase Order Date 8/19/2013

PO Print Date 8/26/2014

Page Number 1 of 1

Order From : VU-DEL003  
DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100  
  
GRAND-MERE, QC G9T 5K7  
CA

Ship To : DART AEROSPACE LTD  
1270  
ABERD  
EEN  
HAWKE  
SBURY,  
ON  
K6A  
1K7  
CANAD  
A

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	819 533 5788	Customer POID	
Vendor Fax	819 533 3494	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	USD
		FOB	FCA - (Free Carrier)
Ship Method	FedEx PI collect		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
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9	71475-20	D3188-2 SPACEPOD BODY	9/19/2014 Yes	1.00 Each	\$0.00
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NCR-14-3858  
DELASTEK RMA# SAV-8458  
NEED REPLACEMENT

9/19/2014

SP 14-10-23

Line Total: \$0.00

Outstanding PO Total: \$0.00

CL

Terms & Condition of  
Purchasing(Suppliers) and  
Procurement Quality Clauses are an  
integral part of our AS9100

Change Nbr: 2

Change Date: 8/26/2014

**DELASTEK Inc.**  
2699 5e Avenue  
Local 14,  
Grand-Mère, Québec G9T 2P7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

<b>Invoice No.</b>	58567
<b>Customer No.</b>	DART US

## Bill To

**DART AEROSPACE LTD**  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship To**

**DART AEROSPACE LTD**  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Telephone : 613-632-5200**

**Contact : Michael Gregoire**

<b>Ship Date</b>	<b>Order Date</b>	<b>Our SO #</b>	<b>Ordered by</b>	<b>Your PO#</b>	<b>Terms</b>
20-10-2014	29-08-2014	24954	Michael Gregoire	PO20980	Net 30 days USA
<b>Ship Via</b>		<b>F.O.B.</b>		<b>Salesperson</b>	<b>GST/PST</b>
Fedex Freight LTL Collect		Point de départ		Melody Shapcott, ext. 235	
<b>Order Qty</b>	<b>B.O. Qty</b>	<b>Current Ship</b>	<b>Item number</b>	<b>Description</b>	
1	0	1	DKC134-0071-SAV	Line #9 N° D3188-2M, Spacepod Body RH U of M: Chaque Dwg. D3188 Rév.: F NRC-14-3858 RMA #SAV-8458 Lot # 64164 1 8814-10-23	

*It is hereby certified that all materials, process and finished items are controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by:

Quality department

**AQ-357**

☐ Cust.      ☐ Adm.      ☐ Quality      ☐ Ship.